

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005287**Date Inspected:** 17-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

CALTRANS OSM Quality Assurance (QA) Inspector, Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island in Shanghai, China. QA Inspector and/or found the following:

Outside Bay 13 lift 3BW: QA Inspector randomly observed ZPMC qualified welder Ni Lei Jiang ID#037723 welding on Corner Assembly bottom plate joint number SEG015A-010 Rep-2. Welder was observed welding in the 1G (flat) position utilizing Shielded Metal Arc Welding (SMAW) process with a 4 mm diameter electrode THJ506Fe-1 (E7018-1). QA Inspector observed the ZPMC QC Inspector Yang Ding verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 90°C and measured the welding parameters to be 160 amps, 24 volts, a travel speed of 99 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-345SMAW-1G (1F)-FCM.

**Summary of Conversations:**

No significant conversations this day.

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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<b>Inspected By:</b>	Prue,Erik	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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